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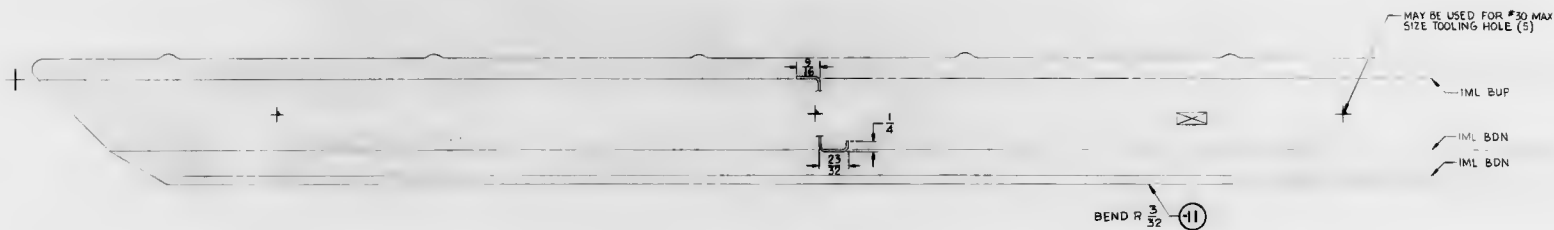
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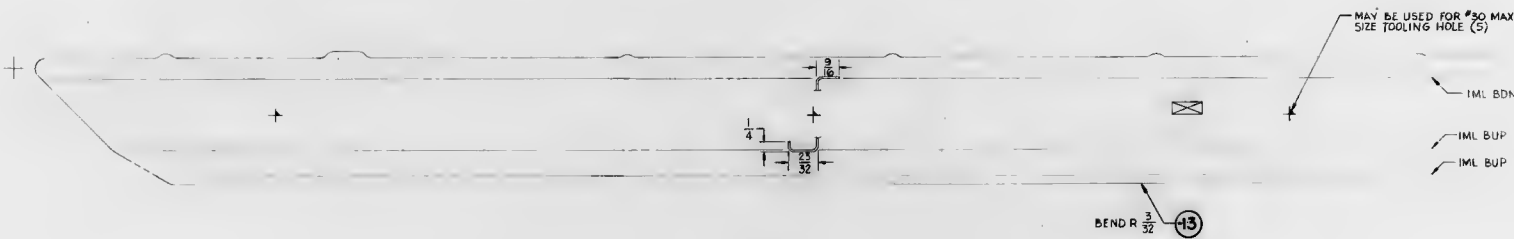
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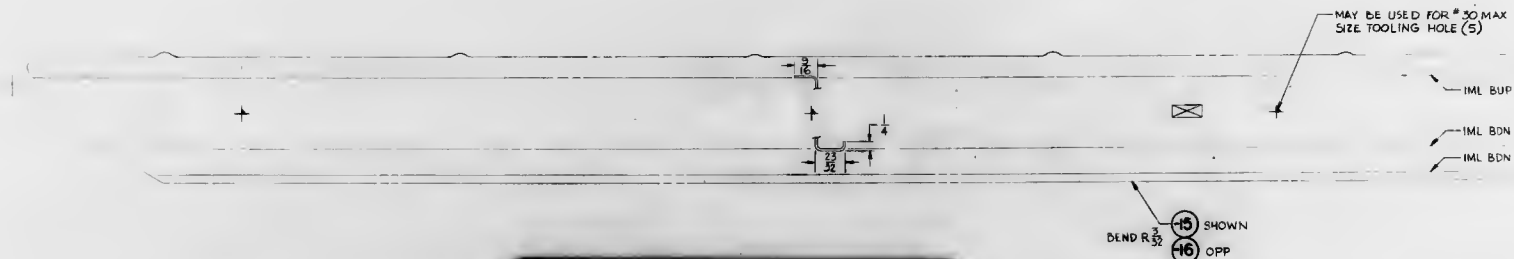
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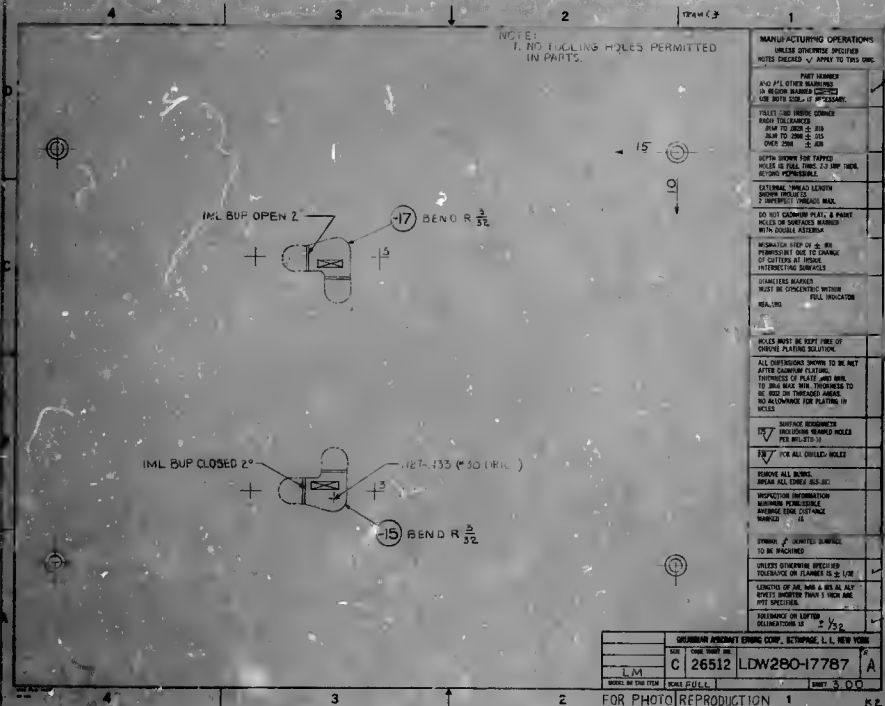
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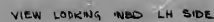
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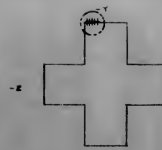
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8- ALL INFORMATION NOT READ TO MANUFACTURER
LDW230-17789-11 IS REP INFO ONLY



8.- ALL INFORMATION NOT READ TO MANUFACTURE
LDN280-17782-4 IS REP INFO ONLY



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JUL 1982		LDW280-17789
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ON LDWZ80-51587-1MS7L ADD MS20470-
AD4(2)

DRILL #40(.097-.102) (2 HOLES) IN - 15

LDW280-17789-15(KLF)

LDW280-17789-⁻¹² SPLICED ADD ON
LDW280-51587-1 IN 37C.

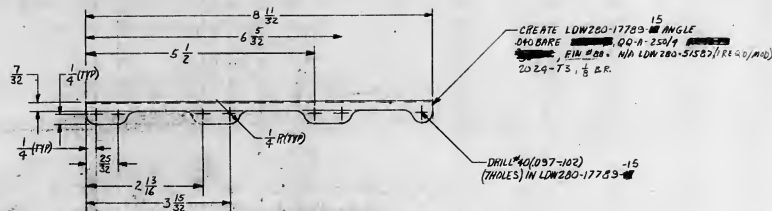
LDW280-17396-13號-4(Ret)

-13
- CREATE LDWZ80-17789-~~1~~ SALICE ~.090 BARE 2029-~~1~~ QQA-2SD/g.
FIL# 88 * : : N/A LDWZ80-51587 (EFF: LM-1/3U, 2 REQ/MD)

ON LDW280-51587-1 IN STL REMOVE & REPLACE MS20970-A04(2)

SECT A-A (SHN)

Sect B-B (OPP)



15
CREATE LDW280-17789-15 ANGLE
D40BARE [REDACTED] QQ-A-250/9 [REDACTED]
[REDACTED], FIN 280. N/A LDW280-51587/1 (R20/MOD)
2024-T3, 1/2 B.R.

DRILL #40(.097-102) -15
(7HOLES) IN LDW280-17789-~~1~~

ADD LDW 280-17783-☐ ANGLE TO ☐
LDW 280-51587-1 INSTL. ☐

52 -N TO CREATE -M-1-
ONLDW 280-54587-1
INSTL

✓ 0320470-AD 6/7) ON LDM 200-5/587-140372

REWORK EXISTING LBN280-11743-11 TO CREATE -
- IDENTICAL EXCEPT PG NO 110, N/A LBN280
51587. REMOVE N/A LBN 280-51587 FROM-11. LM-1(3) 11

FINISH. 886 (ANGLIZI) / LSP 14-9030
T & T = E

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ON LDW280-5159-1/MSIL ADD MS20470
AD4(2)

DRILL #40(097-102) 2 Holes IN - 13

LBN 17793-15/84/

LDN290-17783-12 SPLICED ADD ON
LDN290-51587-1 INSTEAD

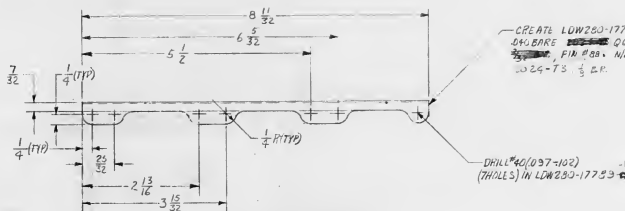
LDWZ80-173 30-13 100-4 (Rett)

-13
-CREATE LDW280-17783-☒ SPLICE ~ .040 BAR# 2029-13, QQA-ZSU/q,
P/L # 08
N/A LDW280 51597 (LFL:LM 1/30, 2 EL40/MID

ON LDW280-54587-1 INSTL REMOVE & REPLACE MS20970-A04(2)

SECT A-A (54N)

SECT B-B (OFF)



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— CREATE LDW280-17783 ~~ANGLE~~
D40 BARE ~~QD-A 250/4~~
FIN #88, N/A LDW280-31587, 18-
029-78.6 BR.

DRILL #40 (097-102)
(7 HOLES) IN LDW 280-17789

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ADD LDW 280-17789-~~2~~ ANGLE TO —
LDW 280-51587-1 INSTL.

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32 TRIM IDW280-17789
-11 TO CREATE - 11-
ONLDW280-51587-1
INSTL.

MS 20970-AD 9(7) ON LDW 200-51587-1 INSTL

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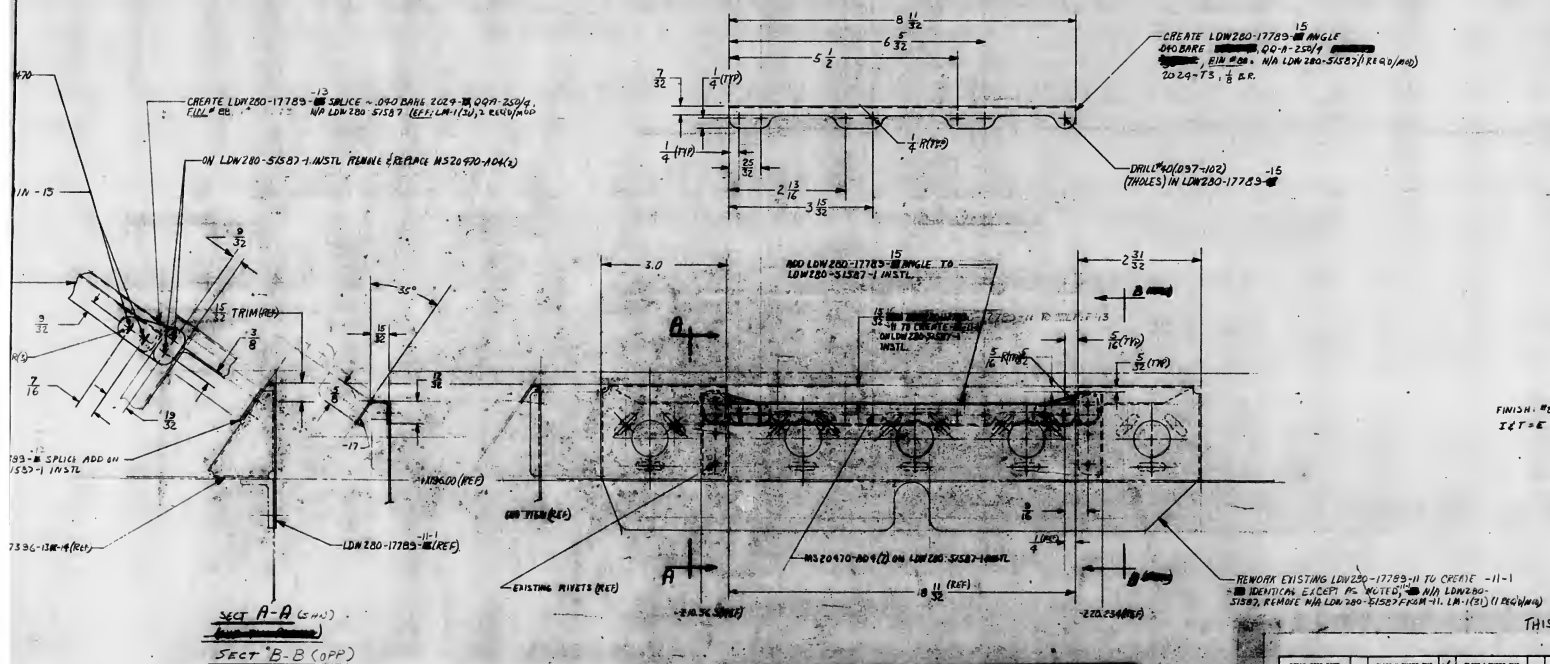
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NOTE: ALL INFORMATION NOT READ TO
MANUFACTURE LDW280-17789-13, -15 & -17
IS FOR REF INFO ONLY.



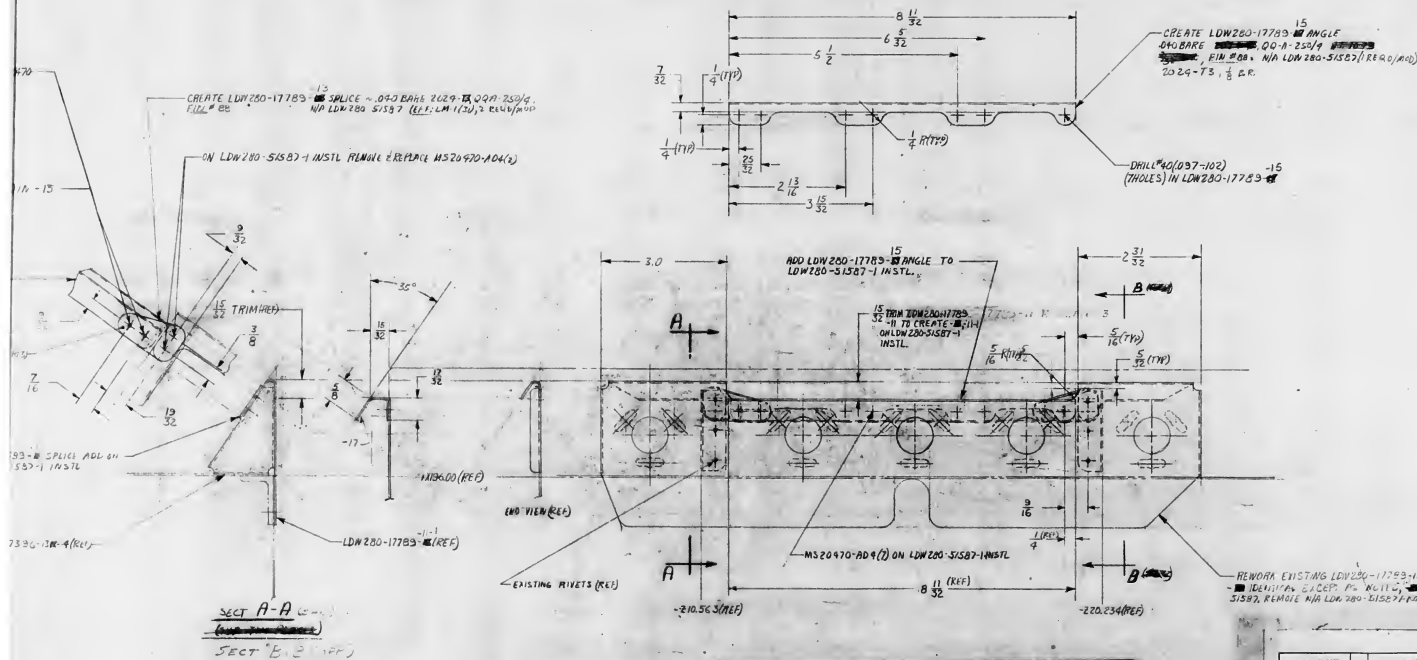
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NOTE: ALL INFORMATION NOT READ TO
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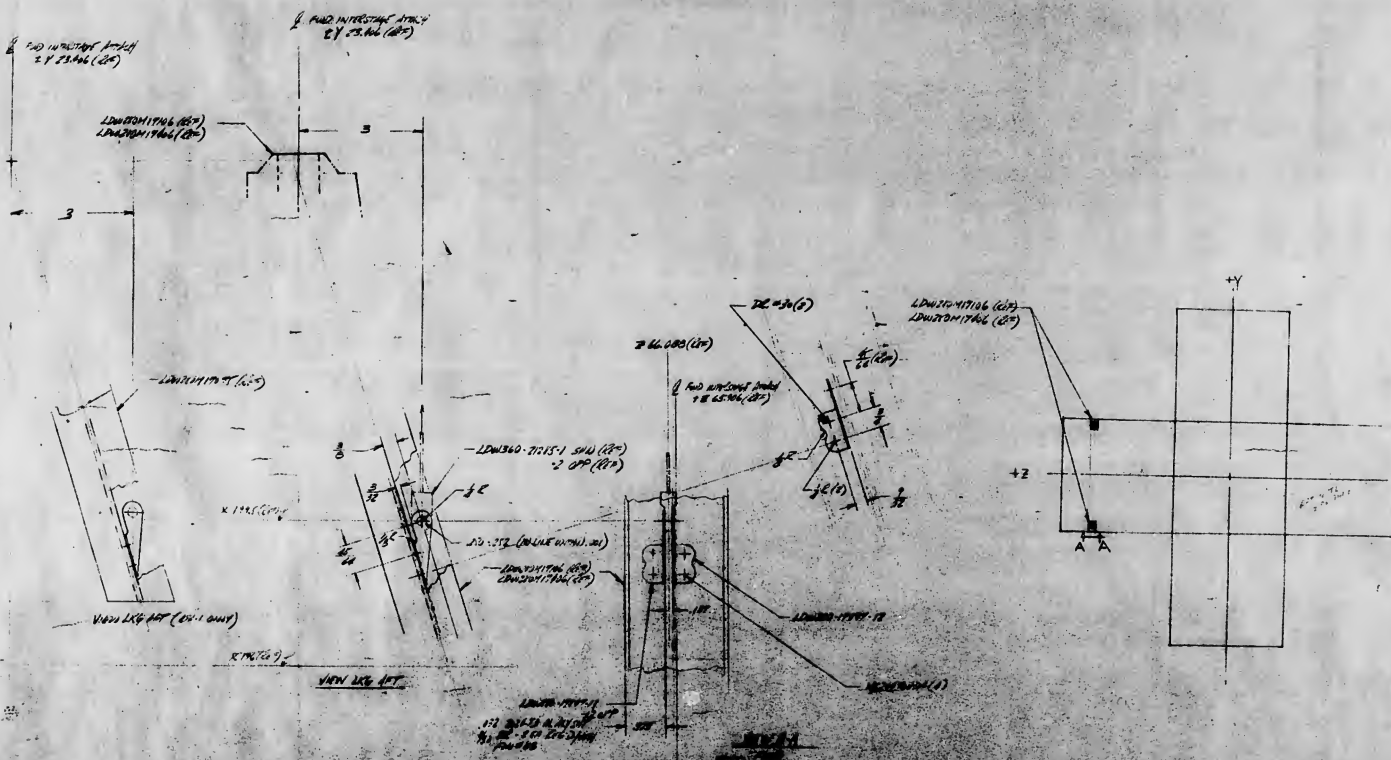
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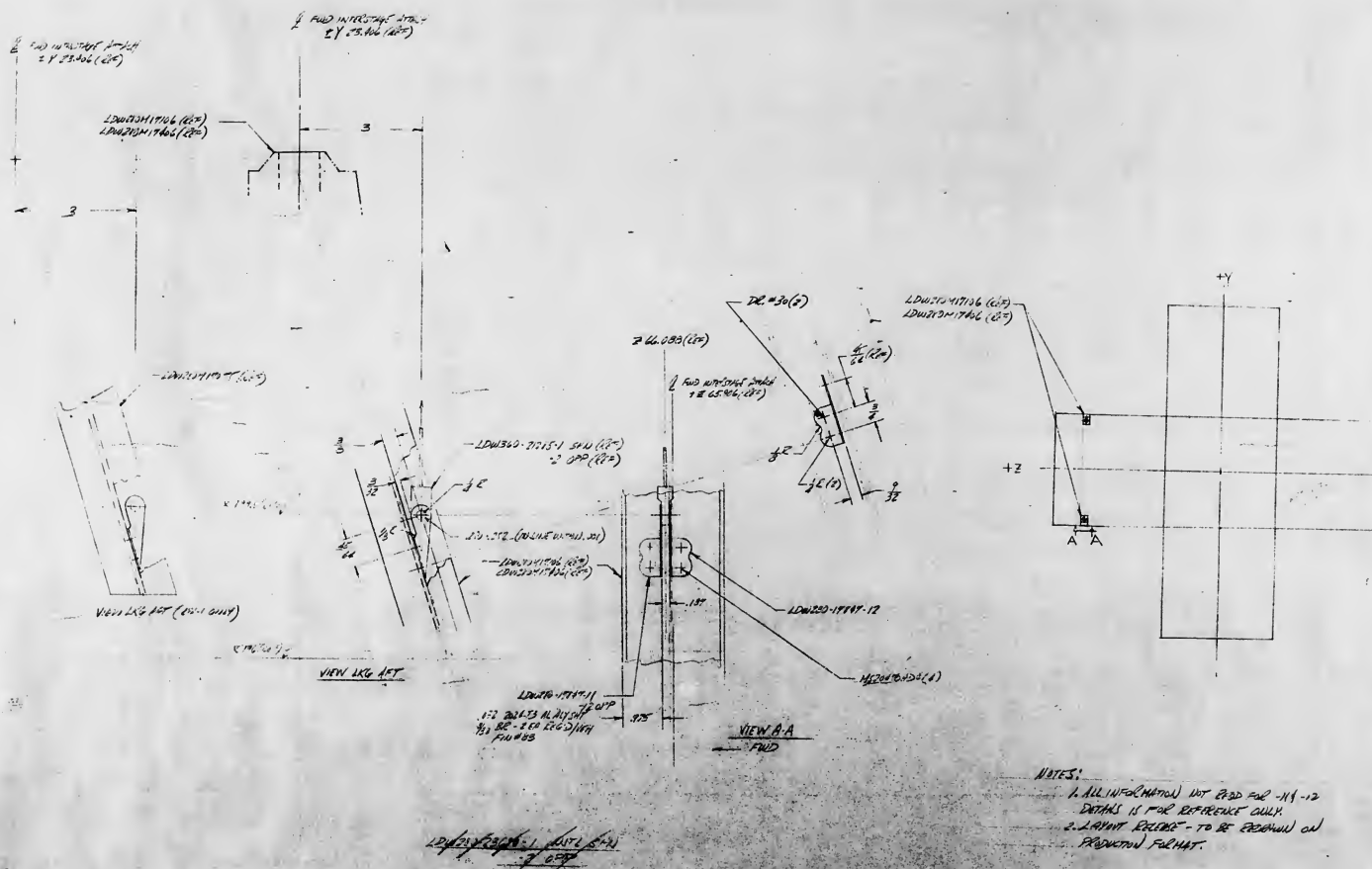


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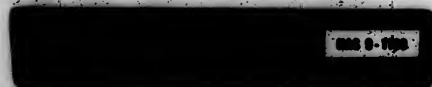
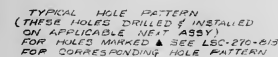
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ADDRESS	
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STATE	
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PHONE	
MODEL	1000
DATE	10/10/10

1.0	<u>SCOPE:</u>	This drawing establishes the requirements for the application of an aluminum pigmented polyester resin based finish coating for radiative temperature control purposes.
2.0	<u>APPLICABLE DOCUMENTS:</u>	The following documents shall be applicable to the extent specified herein:
	<u>Government</u>	
	MIL-T-509AA	Thinner, Mep and Lacquer (Cellulose-Nitrate)
	TT-I-735a	Isopropyl Alcohol
	MIL-M-45202A	Magnesium Alloys, Anodic Treatment of
	<u>Grumman</u>	
	LSP-14-4100	Equipment and Facilities for Surface Preparation and Application of Organic Finishes
	LSP-14-9010	Chemical Conversion Film, Alodine 1200 on Aluminum and Aluminum Alloys
	LSP-14-9012	Chemical Conversion Coating for Magnesium and Magnesium Alloys
	LSP-14-9030	Anodic Coating (Type I - Chromic Acid) for Aluminum Alloys
3.0	<u>REQUIREMENTS:</u>	When Engineering drawings or specifications require the application of aluminum pigmented silicone resin based finish for radiative temperature control purposes, possessing a solar absorbance of 0.18 to 0.23, an emittance of 0.18 to 0.23 at 100°F, and a solar absorbance/emittance ratio of 0.8 to 1.0 at 100°F, it shall be applied in accordance with the following:
3.1	<u>SPECIAL REQUIREMENTS:</u>	A 4" x 6" test panel shall accompany each batch lot of parts or assemblies to be finish coated as outlined herein. These panels shall be of the same materials, receive the same preparation and be finish coated under the prevailing conditions of the production batch lots. The finished panels shall be identified with the batch lot or assemblies and forwarded to Quality Control Laboratory for testing as per 4.0
3.2	<u>MATERIALS:</u>	The following materials are approved for use:
	(a) "Cat-A-Lac" Series 600 Temperature Control Paint	
	(1) Aluminum Pigmented, Non-Yellowing Base, No. G3-1-1	
	<u>SOURCE:</u> Finch Paint and Chemical Co.	
	Torrance, California	
	(b) Cleaner	
	(1) Lacquer Thinner per MIL-T-509AA, Source open	
	(2) Isopropyl Alcohol per TT-I-735a, Source open	
3.3	<u>EQUIPMENT:</u>	Equipment and facilities for preparation and application of material specified herein shall be in accordance with LSP-14-4100.
3.4	<u>PROCEDURES:</u>	
3.4.1		Surface Preparation and Pretreatment - Surfaces to be finish coated in accordance with this drawing shall be prepared as follows:
	(a) Aluminum Alloys - Aluminum alloy surfaces shall be anodized per LSP-14-9030 or Alodined per LSP-14-9010.	

GRUMMAN AIRCRAFT ENGRG CORP., BETHPAGE, L. I., NEW YORK		
SIZE	CODE IDENT NO.	
B	26512	LDW280-17869
SCALE	SHEET 2 00	

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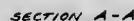
3.4.1	(Continued)	<p>(b) Magnesium Alloys - Magnesium alloy surfaces shall be pretreated with a Type III Dichromate (Dow #7) treatment per MSP-14-9012, or Anodized (Dow #17 Treatment), per MIL-W-45202B, Type II, Class D. The pretreated surface shall then be primed with an epoxy polyamide primer per MSP-14-4354.</p> <p>(c) Fiberglass - Prior to application of the finish coat, the fiberglass surface shall be lightly sanded with #20 or finer wet-dry abrasive paper. The sanded surface shall be wiped with lacquer thinner per MIL-T-6094 after sanding.</p> <p>(d) Polycarbonate Plastics - Prior to application of the finish coat, the polycarbonate surface shall be lightly sanded with #320 or finer wet-dry abrasive paper. The sanded surface shall be wiped with isopropyl alcohol per IT-I-7354.</p>
3.4.1.1		Where a time lapse of 24 hours or greater occurs between pretreatment and finish coat application, or where contamination is evident, parts shall be solvent cleaned with lacquer thinner MIL-T-6094 prior to application of finish coat.
3.4.2	<u>PREPARATION OF COATING MATERIAL:</u>	Thoroughly agitate the base components prior to use. Combine three (3) parts by volume of base coating to 1 part by volume of catalyst solution. Stir to a uniform mix. Allow the mixture to stand a minimum of 30 minutes before applying. The mixture shall be used without further thinning. The usable pot life of the mixture is approximately 8 hours.
3.4.3	<u>APPLICATION:</u>	Apply by spray, one light coat of topcoat and allow to air dry for 1 hour. Apply by spray, one wet crosscoat, taking care to achieve complete coverage. The finished topcoat shall have a total dry film thickness of 1.0 ± 0.2 mils. Air dry, at room temperature, for a minimum of 48 hours before handling. An accelerated cure of the finish may be achieved by air drying at room temperature for a minimum of 2 hours and then baking at 200°F for 4 hours.
3.5	<u>REPAIRS:</u>	
3.5.1		Small Damaged Areas - After the finish coat is thoroughly dry, the affected area shall be touched up by brush application.
3.5.2		Large Damaged Areas - After drying finish coat a minimum of one hour, the entire surface shall be resprayed in accordance with this drawing. Allowable thickness buildup of repaired areas shall not exceed 2 mils average maximum.
4.0	<u>QUALITY ASSURANCE PROVISIONS:</u>	Quality Control shall be responsible for assuring compliance with the requirements of this drawing.
4.1.1		Visual Inspection - The cured topcoat shall have a smooth uniform finish that completely covers the surface to be coated. The finish coat shall be free of any blistering and/or excessive orange peel.
4.1.2		Adhesion Test - Dry tape test
4.1.3		Radiative Characteristics - The average solar absorbance and the average total normal emittance at 100°F of the coating shall be determined from the coated test panels on the finished surface. The solar absorbance shall be measured with a Qier-Dunham Portable Reflectometer. The emittance shall be measured with a Qier-Dunham Portable Radiometer. A log shall be maintained of all radiative characteristics measurements taken, date of measurement, and location of measurement. The radiative characteristics exhibited by the subject finish shall be as specified by paragraph 3.0.
4.2		Parts not meeting the requirements of this drawing shall be rejected or subjected to Materials Review Board Action.

GRUMMAN AIRCRAFT ENGRG CORP., BETHPAGE, L. I., NEW YORK		
SIZE	CODE IDENT NO.	
B	26512	LDW280-17869
SCALE	SHEET 3.00	

THIS IS AN ORIGINAL DWG



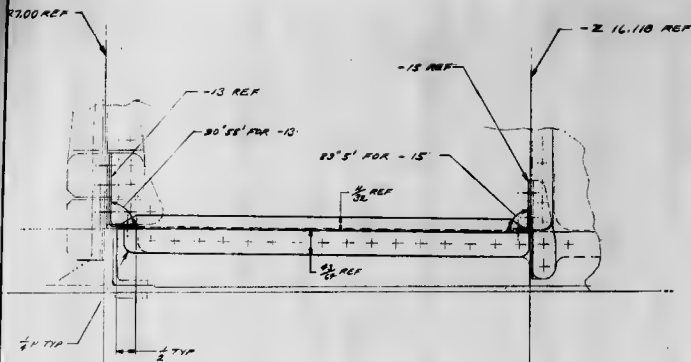
NAS 9-1100



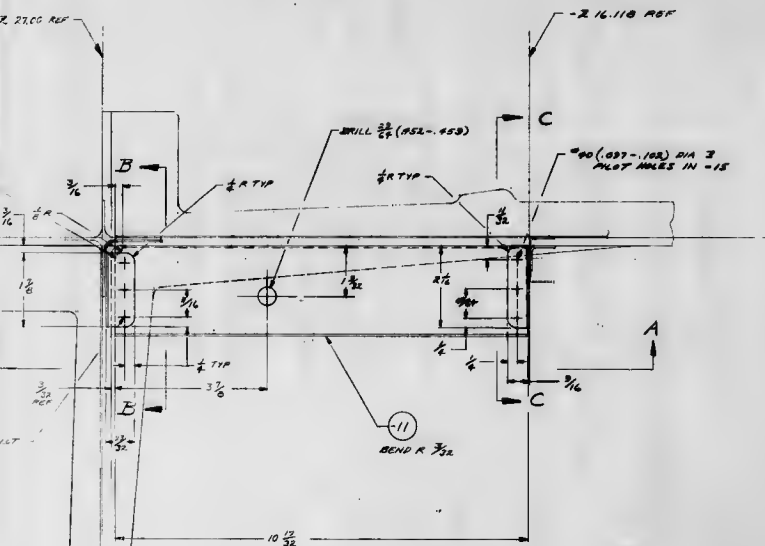
NOTES:



NAS 9-1100



SECTION A-A



SECTION C-C

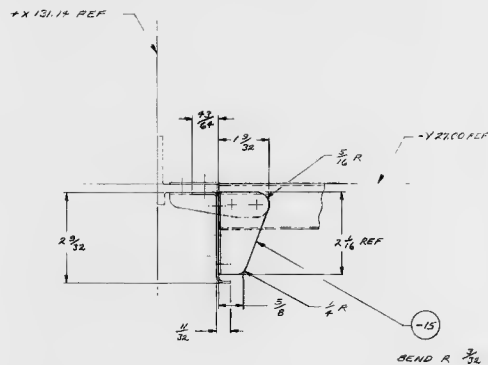
NOTES:

1. NO TOOLING HOLES PERMITTED IN PARTS
2. ALL DIMENSIONATION ON THIS DRAWING THAT IS NOT ASSUMED FOR THE MANUFACTURE OF LENS-80-1787G-11, -13, & -15 IS FOR REFERENCE ONLY
3. LAYOUT RELEASE TO BE REBORN ON PRODUCTION PARTS

MANUFACTURING OPERATIONS	
DATE	11/10/70
BY	J. J. J.
CHECKED	J. J. J.
APPROVED	J. J. J.
PART NAME	
LENS-80-1787G-11, -13, & -15	
QUANTITY	
1000	
MATERIAL	
ALUMINUM 7075-T6	
FINISH	
ANODIZE	
TOLERANCES	
UNLESS OTHERWISE SPECIFIED	
FRACTIONS	
DECIMALS	
ANGLES	
HOLE LOCATIONS	
HOLE DIAMETERS	
HOLE DEPTHS	
HOLE TOLERANCES	
HOLE FINISH	
HOLE DRILLING	
HOLE TAPPING	
HOLE REAMING	
HOLE POLISHING	
HOLE GRINDING	
HOLE LAPPING	
HOLE HONING	
HOLE BURNING	
HOLE ELECTROLYTIC	
HOLE LASER	
HOLE OTHER	

REVISIONS	
NO.	DESCRIPTION
1	26512 LD1-200-1787
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10	

THIS IS AN ORIGINAL DRAWING



SECTION C-C

- NOTES:
1. NO TOOLING HOLES PERMITTED IN PARTS
 2. ALL INFORMATION ON THIS DRAWING THAT IS NOT REQUIRED FOR THE MANUFACTURE OF EDW280-17870-11, -13, & -15 IS FOR REFERENCE ONLY
 3. LAYOUT RELEASE TO BE REDRAWN ON PRODUCTION FORMAT

[illegible]

0 2 / 0 2

NAS 9-1100

		GOLDMAN AIRCRAFT ENGINE CORP., BETHPAGE, L.I., NEW YORK	
DATE	J	DATE SHIPPED BY	26512
LEAD		LD#	200-1787
REASON FOR YOUR ORDER	ORD#	DATE	SHIPPED

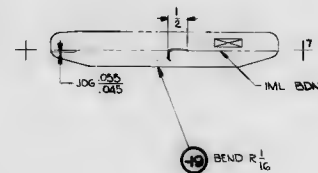
THIS IS AN ORIGINAL DWG

ENG 77.1 12-68

THIS DWG SUPERSEDES LDW280-17882 N.C. 5-31-66

01

NAS 9-1100



LM		E 26512		LDW280-17882		A	
DATE 10-10-78		TIME 10:00		PAGE 3		OF 3	

[illegible]

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PLAS 9-1100

				LDW280-17885 B							
LM	LDW280-23579	LM-15(45)	1 EA					LM	LDW280-23579	LM-5(45)	2
LM	LDW280-23579	LM-14(44)	1 EA					LM	LDW280-23579	LM-15(45)	2
		LM-13(43)								LM-14(44)	
		LM-12(42)								LM-13(43)	
		LM-11(41)								LM-12(42)	
		LM-10(40)								LM-11(41)	
		LM-9(39)		LM	LDW280-23579	LM-2(32)	1 EA			LM-10(40)	
		LM-8(38)		LM	LDW280-23579	LM-3(33)	1 EA			LM-9(39)	
		LM-7(37)		LDW280-17885-19-21						LM-8(38)	
		LM-6(36)								LM-7(37)	
		LM-5(35)								LM-6(36)	
		LM-4(34)								LM-5(35)	
		LM-3(33)								LM-4(34)	
		LTA-3(13)								LM-3(33)	
LM	LDW280-23579	LTA-3(13)	1 EA	LM	LDW280-23702	LTA-3(13)	1 EA	LM	LDW280-23579	LTA-3(13)	2
MODEL OR END ITEM	NEXT ASSY	MODULE OR SER NO.	REQD PER MODULE OR END ITEM	MODEL OR END ITEM	NEXT ASSY	MODULE OR SER NO.	REQD PER MODULE OR END ITEM	MODEL OR END ITEM	NEXT ASSY	MODULE OR SER NO.	REQD PER MODULE OR END ITEM
PART NO. LDW280-17885-23-25		GAEC SCH NO.		PART NO. LDW280-17885-15-16-17		GAEC SCH NO.		PART NO. LDW280-17885-27		GAEC SCH NO. 51-2	

SH REV STATUS: FOR DESCRIPTION OF REV SEE SUBQ SH				UNLESS OTHERWISE SPECIFIED				CONTRACT NO. NAS 9-1100				LINE ITEM #1				DOCUMENTATION TYPE II				
SHEET	1,00	1,10	2,00	3,00	DIMENSIONS ARE IN INCHES				DRAWN BY J. COBB 5-2-66				RELIABILITY				GRUMMAN AIRCRAFT ENGRG CORP			
REV	B	B	B	B	TOLERANCE UNLESS SPECIFIED				LAYOUT BY C. DEANGELO								BETHPAGE, L. I., NEW YORK			
SHEET					FRACTIONS - DECIMALS - ANGLES				CHECKED BY JS 5-3-66								ANGLE			
REV					$\pm 1/32 \pm .020 \pm 1/2^\circ$				GR LEADER J. H. G. 5/1/66								DESCENT STAGE - SCIENTIFIC			
SHEET					ORIG DWG AUTH				REV DESIGNED J. H. G. 5/1/66								EQUIPMENT - END CLOSURE			
REV					DETAIL SPEC REQUIREMENT				STRUCTURE J. H. G. 5/1/66				PROJ ENGR J. H. G. 5/1/66				SIZE CODE IDENT NO.			
LAST SECT LTR USED					CLASS II ENGRG CHANGE				STRUCTURE J. H. G. 5/1/66				REL GROUP J. H. G. 5/1/66				B 26512 LDW280-17885 B			
LAST DASH NO. USED	-21				CLASS I ENGRG CHANGE				WEIGHTS J. H. G. 5/1/66								SCALE NONE SHEET 1,00 OF 4			

1 NG 77.1 12-68

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NAS 9-1100

GRUMMAN AIRCRAFT ENGINEERING CORP.
 CODE IDENT NO. 26512
 ENGINEERING ORDER

DWG. LEO280
 NO. 913
 REV. 10/63

FOR THE FOLLOWING PARTS ADD TM-5/R REQUIREMENTS, N/A LON280-23579 FOR
 QUANTITIES NOTED.

DWG. NO. *	TITLE	REQD.	CAS. NO.
	SEE DWG.		
LM280-11729-11		1	A5
-17885-23		1	
-17885-25		1	B8
-17885-27		2	
MT282-11		1	A1
-17886-24		1	
-17886-21		1	C7
-17886-23		1	
-17886-25		1	
-17973-11		1	A5
-17973-15		1	
-18524-11		1	
-18524-13		1	A1
-18524-15		1	
-18524-17		1	
-18524-15		1	A3
LM280-18478-11	SEE DWG.	1	A2

ADD TM-5/R REQUIREMENTS

DATE: 10/63

BY: E. RANSTON / G. HANSMANN

SECTION: X3352

GROUP NO. 335

REV. 10/63

ON - X-100 TM-5/R REQUIREMENTS

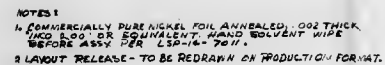
DATE: 10/63

BY: E. RANSTON / G. HANSMANN

SECTION: X3352

GROUP NO. 335

REV. 10/63



BROOKMAN AIRCRAFT ENGINE CORP., BETHPAGE, L. I., NEW YORK	
FOR	BOOK ORDER NO.
J	26512 LDW280-17894
NAME OF THE FIRM	PRICE \$14.95

03/03

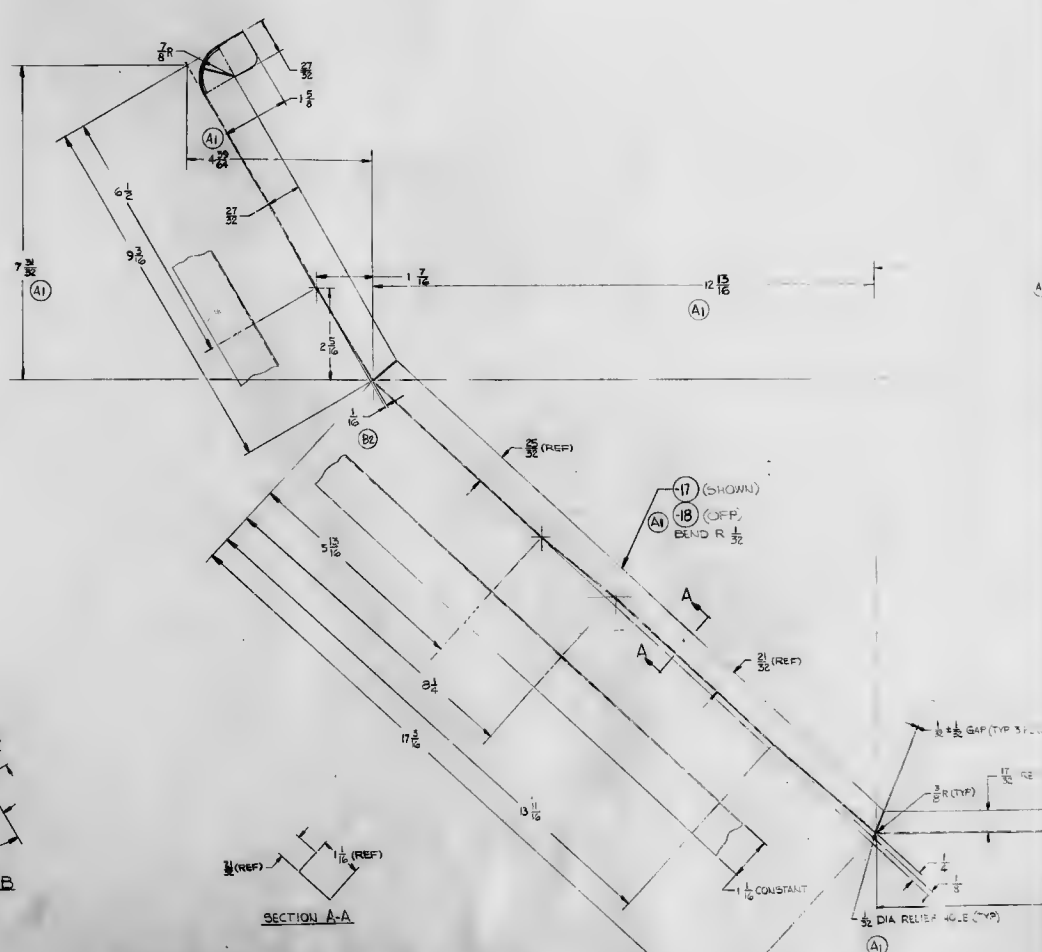
NAS 9-1100

77.112-9

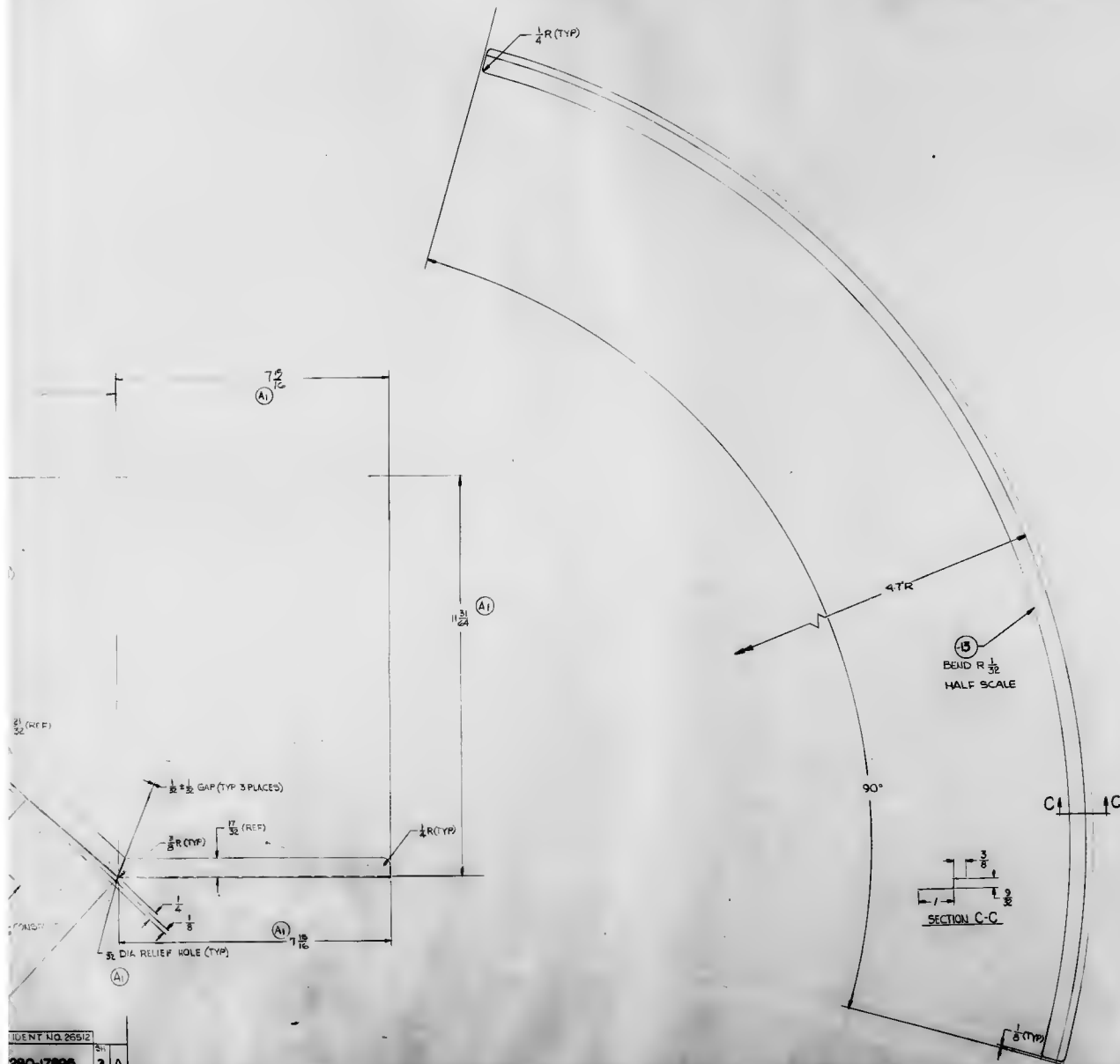
SUPERSEDES LDW280-17895 NO CHG OF 5-6-66

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NAS 9-1100



NOTE:
1. COMMERCIALY PURE NICKEL FOIL ANNEALED
.002 THICK, PER ASTM B162. HAND SOLVENT WIPE
BEFORE ASSY PER LSP-14-7011.

[illegible]

NAS 9-1100

COMMON AIRCRAFT WORKS CORP., SETYPAGE, L I, NEW YORK			
REF	DATE SENT IN		
J	26512	LDW280-17895	E
LEM			
DATE OF BIRTH	DATE OF DEATH	DATE	3.00

[illegible]

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WAS 9-1100

REVISIONS FOR CONTINUATION OF REVISION OF SHEET									
REV. NO.	DATE	BY	REVISION	EFFECTIVITY	REVISIONS BY		REVISIONS BY	REVISIONS BY	REVISIONS BY
					REVISIONS BY	REVISIONS BY			
1	10-14-66		REVISIONS BY						
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99	10-14-66		REVISIONS BY						
100	10-14-66		REVISIONS BY						

01

MS 9-1100

										LDW280-17904-9	E	CLIP	AL ALLOY SH	QQ-A-250/12	7075	050x2x2	T6	88		
										LDW280-17904-17	E	CLIP	AL ALLOY SH	QQ-A-250/12	7075	050x3x4	T6	88		
										LDW280-17904-8	E	PLATE	AL ALLOY SH	QQ-A-250/12	7075-T6	050x2x2	NONE	88		
										LDW280-17904-13	E	BRACKET	AL ALLOY SH	QQ-A-250/12	7075	040x3x6	T6	88		
										LDW280-17904-11	E	BRACKET	AL ALLOY SH	QQ-A-250/12	7075	040x3x4	T6	88		
QTY PER ASSEMBLY										CODE IDENT	PART NO	U&T	NOMENCLATURE OR DESCRIPTION	MATERIAL	GOVT SPEC	COML SPEC	STOCK SIZE	PROCESS SYM	FINISH NO	ZONE

SYM OR NO.	PROCESS OR FINISH	GRUMMAN SPEC OR MILITARY SPEC	SYM OR NO.	PROCESS OR FINISH	GRUMMAN SPEC OR MILITARY SPEC	SYM OR NO.	PROCESS OR FINISH	GRUMMAN SPEC OR MILITARY SPEC	IDENTIFICATION AND TRACEABILITY IN ACCORDANCE WITH :
									NONE
									GRUMMAN AIRCRAFT ENGRG CORP., BETHPAGE, L. I., NEW YORK
									SIZE CODE IDENT NO.
									B 26512 LDW280-17904 C
									SCALE NONE SHEET 2.00

ENG 77.2 7-46

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NAS 9-1100

GRUMMAN A/CRA: ENGINEERING CORP.
CODE IDENT NO. 25512

ENGINEERING ORDER

DWG. NO. LEO 280
CONTRACT NO. LDW280B7164
EO NO. 1682

FOR THE PART NO'S NOTED *, EFFECTIVE LM-10(40)
THRU LM-14(44) ~ REVISE THE NEXT ASSEMBLIES
ADD: LTA-11(23) & LTA-3 * 1(460) EFFECTIVITY FOR N/A'S
(QTY. REMAINS THE SAME AS THAT OF LM-10(40))

PART NO *	N/A (WAS)	N/A (NOW)	DWG. TITLE	CHG. NO.
LDW280-17906-13	LDW280-23542 LDW280-23543 LDW280-23544	LDW280-60542 LDW280-60543 LDW280-60544	SEE DWG.	B4
LDW280-18638-1 -2, -3	LDW280-23543 LDW280-23544	LDW280-60543 LDW280-60544	SEE DWG.	A5

MLCD 3890 PKG 56 Pg 3-445 (5)

FOR * N/A (WAS) DESCRIPTION OF CHG LDW280-60542-60543
LDW280-23542-23543 & 23544
FOR LM-10(40) THRU LM-14(44)
LDW280-17906-13 EFFECTIVITY

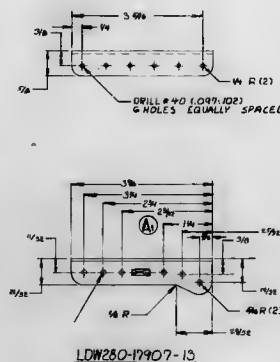
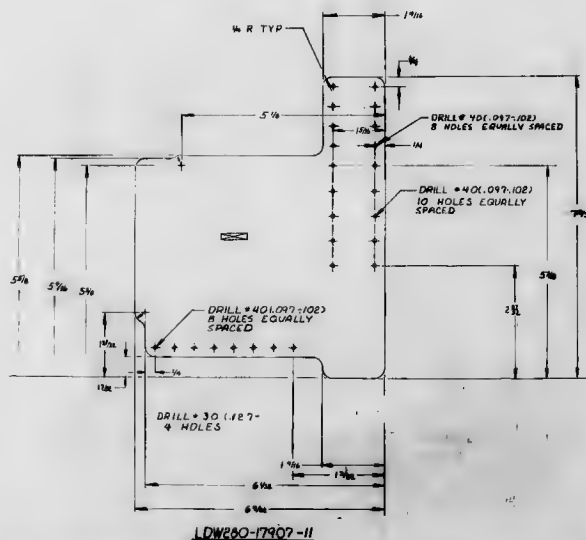
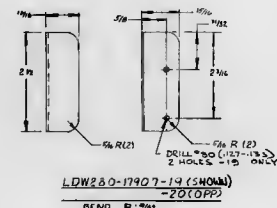
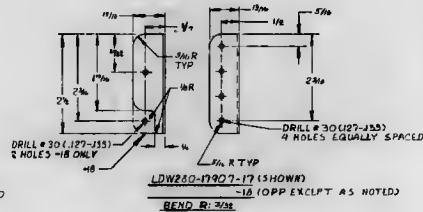
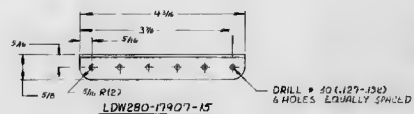
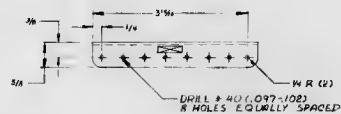
REDESIGN OF LOWER DECK'S
FOR EXTENDED PROP. TANKS

DATE	APPROVED BY	DATE	APPROVED BY	DATE	APPROVED BY
10-24-69	R. BEHAN/P. THORJUSEN	8/16/69	VDI		

GROUP NO 335 PL 28

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NAS 9-1100

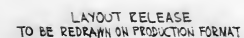


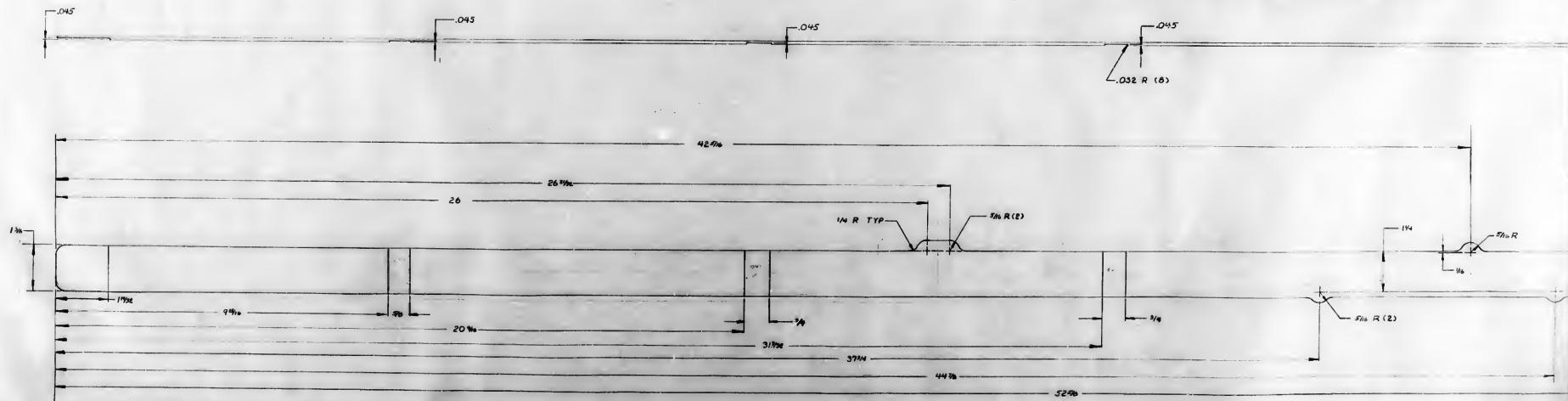
NOTES:
1-LAYOUT RELEASE-TO BE REDRAWN ON PRODUCTION FORMAT
2-NO TOOLING HOLES PERM T.T.C. IN PART

MANUFACTURING OPERATIONS	
1. CHECK DRAWING FOR CORRECTIONS	
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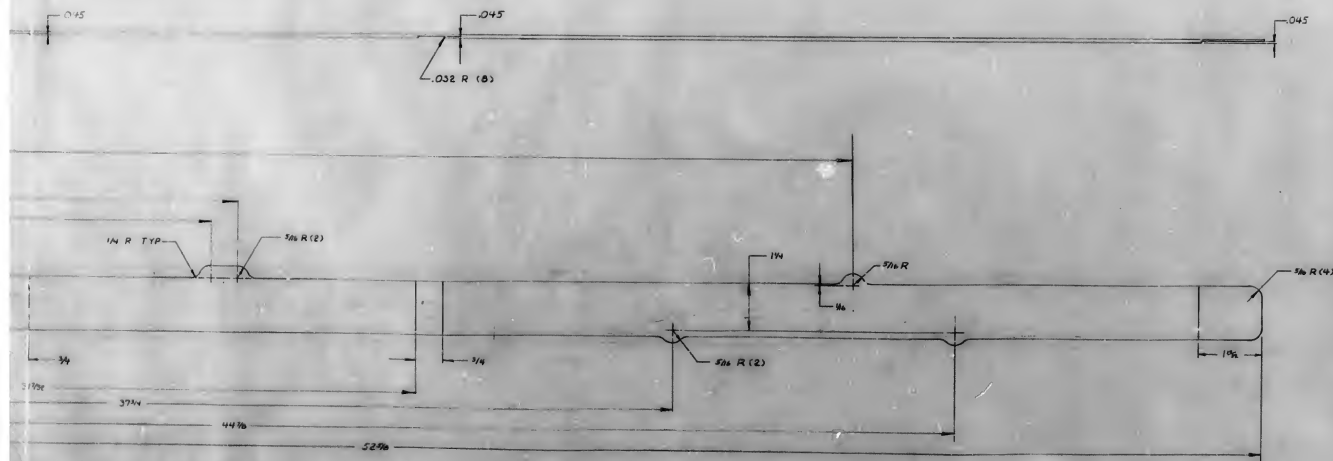
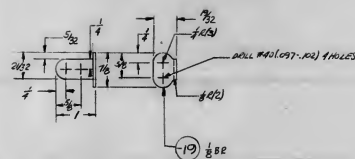
DATE	26512	LDW280-17907
BY		
CHECKED		
DATE		

[illegible][illegible]

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LDW280-17918-11

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NOTES:

LAYOUT RELEASE - TO BE REDRAWN ON PRODUCTION FORMAT

1. PRIOR TO ALDINE FINISH 76, DEOXIDIZE PER LSP 14-7020
2. NO TOOLING HOLES PERMITTED IN PARTS (EXCEPT AS NOTED)

02/02

NAS 8-1100

		GRANDMAN AIRCRAFT ENGRS CORP., BETHPAGE, L. I. NEW YORK	
	NO.	CODE	UNIT NO.
	J	26512	LDW280-17918
LEM			
AMOUNT ON HAND FROM	PAID FULL		UNIT 3.00

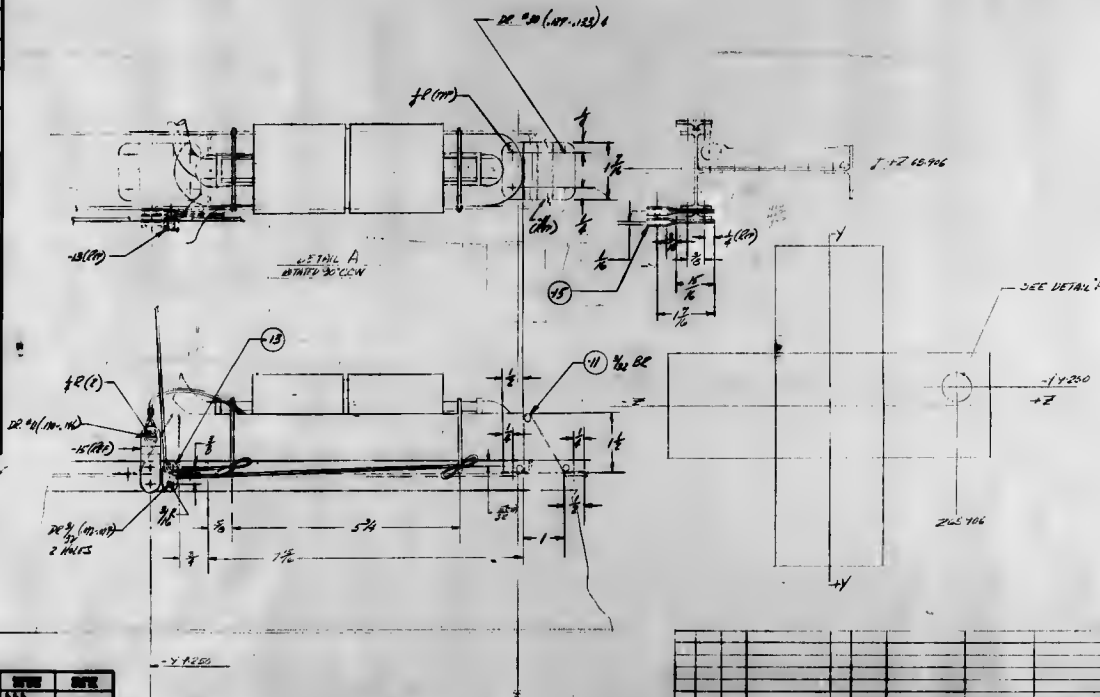
LDW280-17918-11

1 DW280-19018

DW 280-17219

REVISIONS	DATE	BY	CHKD
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NOTES:
 1. DRAWING (RELATIVE TO AN ARCHITECTURAL) DRAWING
 2. ALL DIMENSIONS ARE IN INCHES
 3. ALL DIMENSIONS ARE TO FACE UNLESS OTHERWISE SPECIFIED



REVISIONS	DATE	BY	CHKD
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REVISIONS	DATE	BY	CHKD
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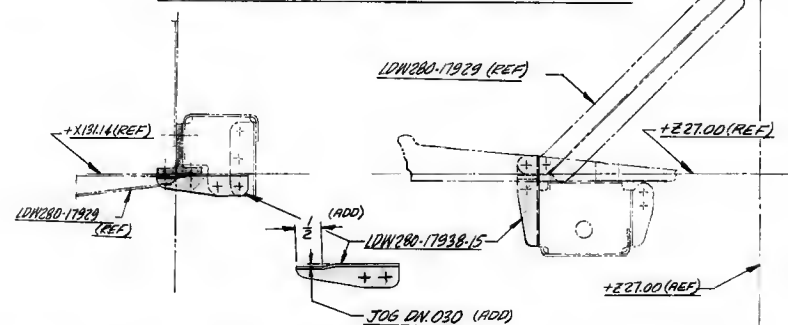
REVISIONS	DATE	BY	CHKD
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GRUMMAN AIRCRAFT ENGINEERING CORP.
CODE IDENT NO. 26512

ENGINEERING ORDER

DWG NO. LDW280-17938 E.O. NO. B1
CONTROL DATE NO. LM-2-2877

REWORK - 15 BY ADDING .030 JOGGLE AS SHOWN:



DETAIL SPEC REQ		CL 22 ENGNG CHG		CL 23 ENGNG CHG		2	
REASON FOR E.O.				DESCRIPTION OF E.O.			
ANGLE INTERFERED WITH TAB ON BRACKET				ADDED .030 JOGGLE TO - 15			
EFFECTIVITY		DRAWING CHANGE REASON		DISPOSITION OF PARTS		APPROVED BY	
PRECEDING ACTIVITY NO.	CAEC UNIT NO.	SUB. CONTROL UNIT NO.	✓	RECORD	✓	DATE	10/9
LM	LM-2(32)		✓	REWORK	✓	DATE	10/9
LM	THRU		✓	REWORK	✓	DATE	10/9
LM	LM-6(36)		✓	REWORK	✓	DATE	10/9
PRIORITY		C		DESCENT STAGE FUEL FLOW/RETR LINE		LDW280-17938	
ISSUED BY		LIAISON / E. NEFF X3604		SECTION		V.D.I.	
GROUP NO.		335		PL		35	

01

NAS 9-1100

ENC 77.1 62-48

SUPERSEDES LDW280-17943 NO CHG. 6-27-66

01

NAS 9-1100

LDW280-17943-21 E STRUT ALLOY TUBE QQ-A-255/9 7075 1/800 X .083 X 1/6 FACILITY 88									
-19									
-17									
-13									
LDW280-17943-11 E STRUT ALLOY TUBE QQ-A-255/9 7075 1/800 X .083 X 21 3/4 FACILITY 88									
1/800 X .083 X 22 3/4									
1/800 X .083 X 14 1/4 FACILITY 88									
QTY PER ASSEMBLY CODE IDENT PART NO. MAT NOMENCLATURE OR DESCRIPTION MATERIAL GOVT SPEC COMIL SPEC STOCK SIZE PROCESS SYM FINISH NO. ZONE									
SYM OR NO.	PROCESS OR FINISH	GRUMMAN SPEC OR MILITARY SPEC	SYM OR NO.	PROCESS OR FINISH	GRUMMAN SPEC OR MILITARY SPEC	SYM OR NO.	PROCESS OR FINISH	GRUMMAN SPEC OR MILITARY SPEC	I & T: IDENTIFICATION AND TRACEABILITY IN ACCORDANCE WITH :
									NONE
									GRUMMAN AIRCRAFT ENGRG CORP., BETHPAGE, L. I., NEW YORK
									SIZE CODE IDENT NO.
									B 26512 LDW280-17943 A
									SCALE NONE SHEET 200

ENR 772746

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NAS 9-1100

GRUMMAN AIRCRAFT ENGINEERING CORP.

CODE IDENT NO. 26512

ENGINEERING ORDER

DWG NO. LDW280-17959
CONTROL INFO NO. LDW280B8375

EO NO. B5

ENG 22.1 REV 3-45

FOR -11-1, -13 & -15. N/A LDW280-60587 WAS
LDW280-54587 FOR LM10(40) THRU LM14(44) & LTA11(23).
ADD LTA3DR1(460) REQMTS. QUANT. & N/A
SAME AS LM-10(40)

DETAIL SPEC REQ	CL 12 ENGNG CHG	CL 2 ENGNG CHG	✓ LCR 3890	PKG 78	PG 3	(5)
REASON FOR ED			ON -11-1, -13 & -15 DESCRIPTION OF ED			
REDESIGN OF UPPER TANK			N/A LDW280-60587 WAS LDW280-54587 &			
BRACKET FOR EXTENDED TANKS			ADDED LTA11(23) & LTA3DR1(460) REQMTS			
MODEL	PROCESSES ACTIVITY NO.	DATE UNIT NO.	SUB CENTER UNIT NO.	DRAWING CHANGE REQ	DISPOSITION OF PARTS	APPROVED BY
LM	LM-10(40) THRU LM-14(44)			✓	NOT ASS	DATE
LM	LTA3DR1(460) &			RECORD	REWORK	DATE
LM	LTA11(23)			✓	REWORK	DATE
ISSUED BY T. COTTER / DRAGAS 887222			SECTION VPI			
GROUP NO. 335			PL 25			

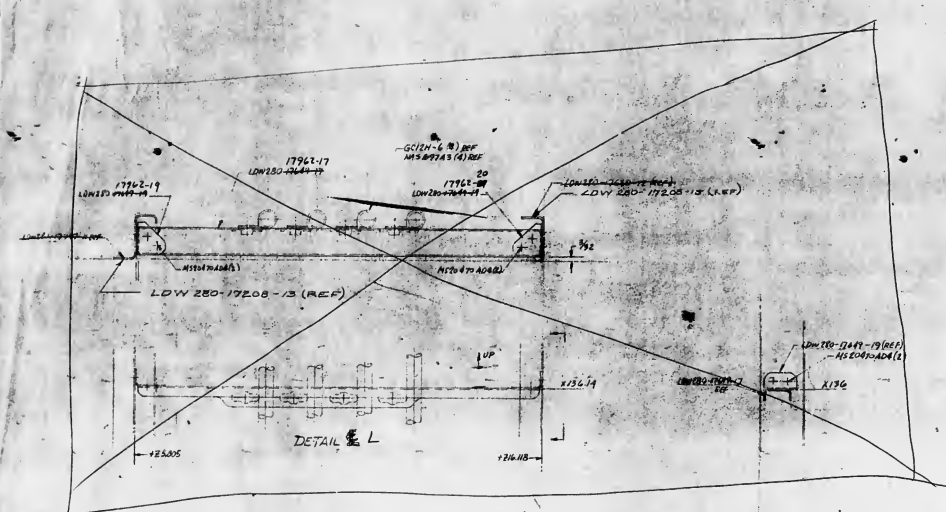
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NAS 9-1100

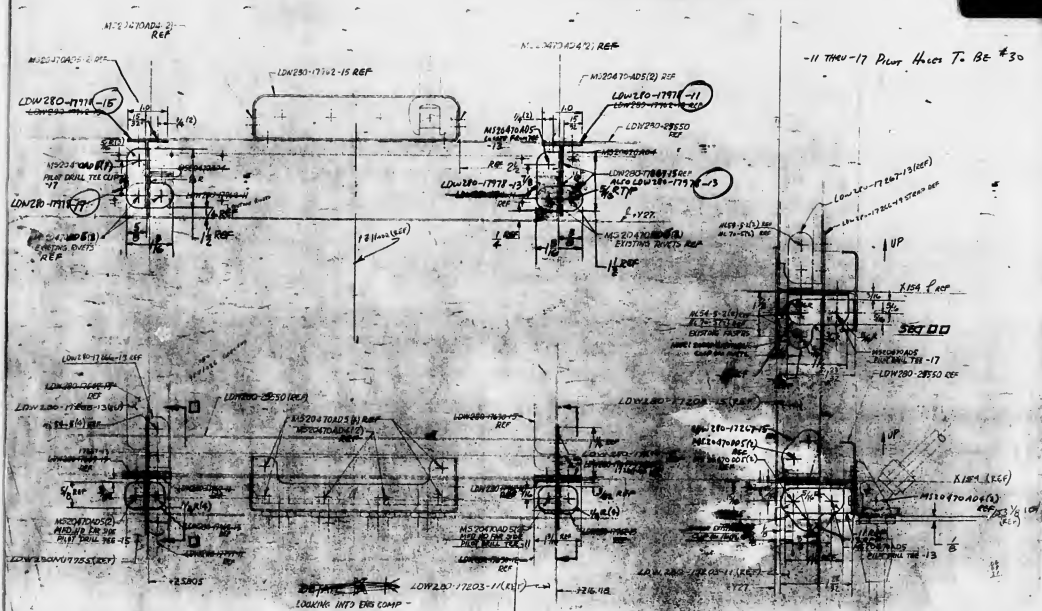
SUPERSEDES LDW280-17977 N.C. 6-23-66

NAS 9-1100

17962-19
LDW150-17208-13



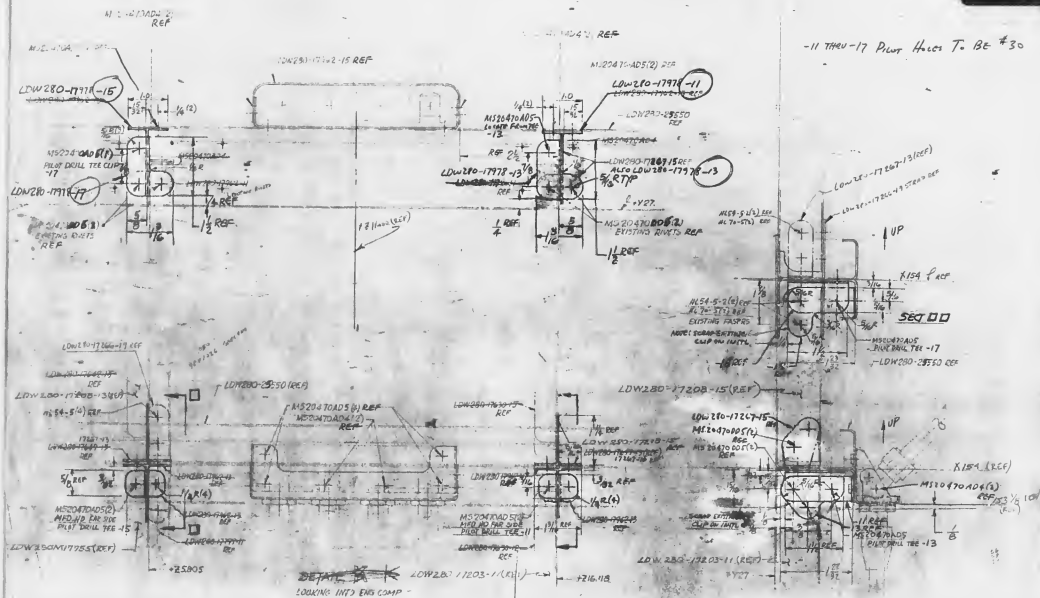
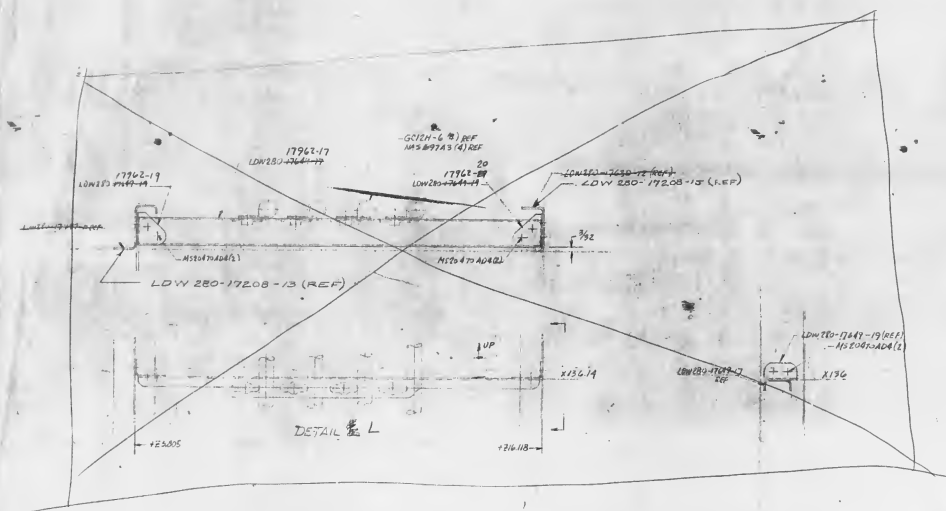
01



MANUFACTURING OPERATIONS	
UNLESS OTHERWISE SPECIFIED	NOTES CHECKED BY: ADITYA TO THIS Dwg.
PART NUMBER	
AND ALL OTHER MARKINGS	
IN DESIGN DRAWING	
USE BOTH SIDES IF NECESSARY	
FILET AND RADIUS CORNER	
RADIUS TOLERANCES	
OVER TO .005 IN	
UNDER TO .005 IN	
OVER .005 IN	
UNDER .005 IN	
DEPTH SHOWN FOR TAPPED	
HOLES IS FULL LENGTH 2.5 HYP HOLES	
BEYOND PERMISSIBLE	
EXTERNAL THREAD LENGTH	
SHOWN INCLUDE	
2 IMPROVED TOLERANCES MAX	
DO NOT COUNTER PLATE & PAINT	
HOLES OR SURFACES MARKED	
WITH DOUBLE ASTERISK	
MATERIAL STEP BY .005	
PERMISSIBLE DUE TO CHANGE	
OF CUTTERS AT INSURE	
INTERFACING SURFACES	
DIAMETERS MARKED	
MUST BE CONCENTRIC WITHIN	
INDICATOR	
PLATING	
HOLES MUST BE KEPT FREE OF	
CORROSION PLATING SOLUTION	
ALL DIMENSIONS SHOWN TO BE MET	
AFTER CATHODIC PLATING	
THICKNESS OF PLATE SHALL BE	
TO .005 MAX. WITH TOLERANCE	
TO BE .005 ON TOLERANCE	
NO ALLOWANCE FOR PLATING ON	
HOLES	
SURFACE ROUGHNESS	
INCLUDING HATCHED HOLES	
PER MIL. SEE 10	
FOR ALL DRILLED HOLES	
REMOVE ALL BURRS	
BREAK ALL EDGES .005-.010	
INSPECTION INFORMATION	
MINIMUM PERMISSIBLE	
AVERAGE EDGE DISTANCE	
MINIMUM	
IS	
SHOWN	
IDENTIFIES SURFACE	
TO BE MEASURED	
UNLESS OTHERWISE SPECIFIED	
TOLERANCE ON FINISHES IS .005	
LENGTH OF AN HOLE & HOLE ARE	
HOLES SHORTER THAN 1 INCH ARE	
NOT SPECIFIED	
TOLERANCE ON LISTED	
DEVIATIONS IS	

NAS 9-1100

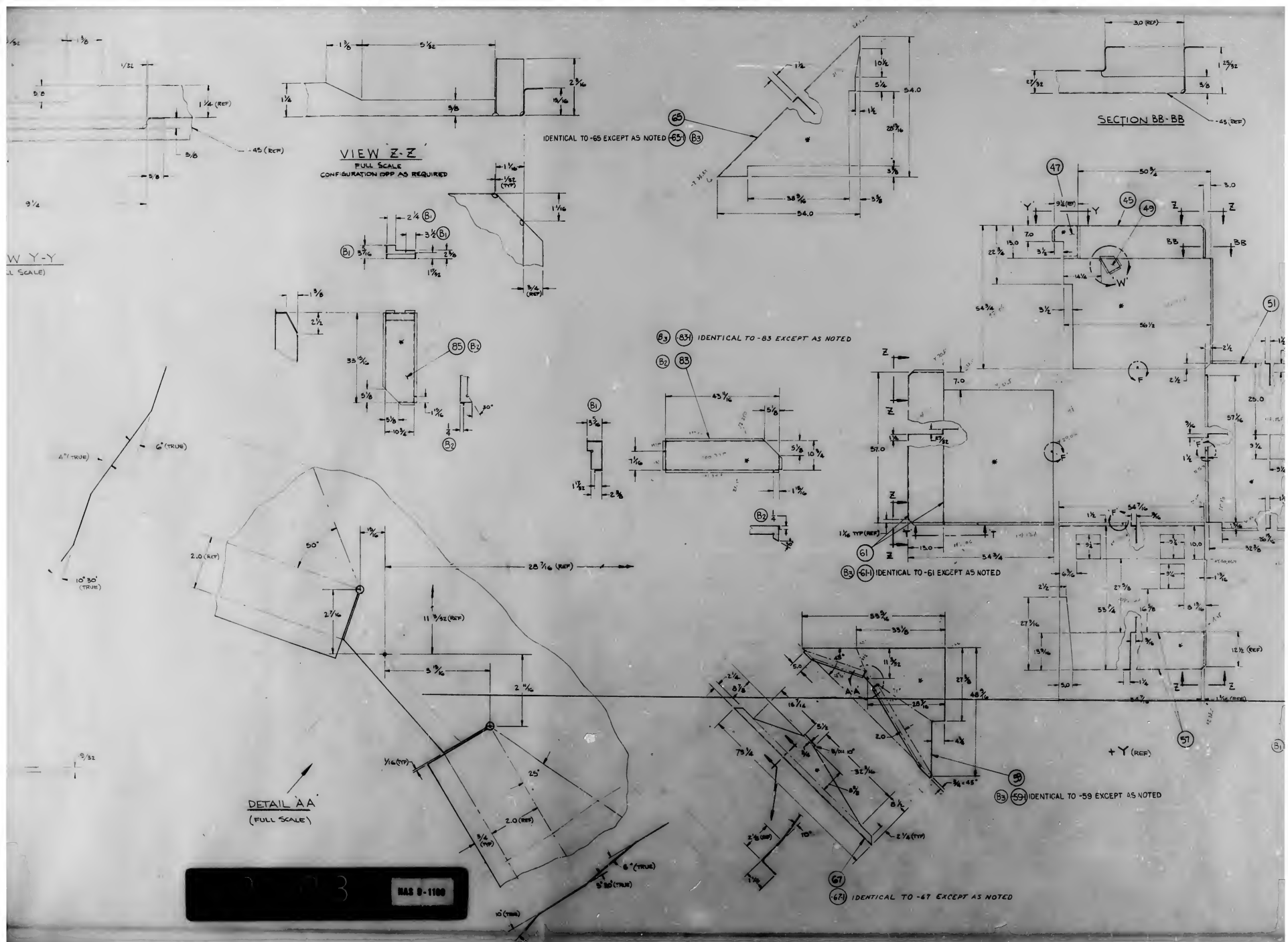
GUMPERT INDUSTRIES CORP., BETHPAGE, L. I., NEW YORK	
J 26512	
DATE OF LAST REV.	SCALE
DATE	SCALE

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NAS 9-1100

GRUMMAN AIRCRAFT ENGINE CORP., BETHPAGE, L.I., NEW YORK	
SERIAL NO.	26512
MODEL OR TAG ITEM	

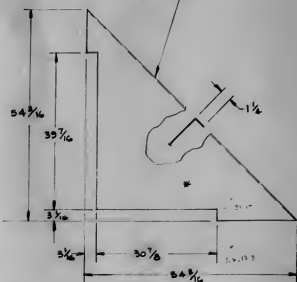


SECTION BB-BB

83 53 IDENTICAL TO 53 EXCEPT AS NOTED

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2 1/2

25.0

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IDENTICAL TO 53 EXCEPT AS NOTED

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6. PARTS TO BE FORMED WITH BOREHOLE GEAR NEAR SIDE AS SHOWN TRUS 6
5. ALL FLANGES NOT SPECIFIED TO BE 3/4" WIDE.
4. ALL RELIEF RADII TO BE 1/8" - 5/32" EXCEPT AS NOTED.

3. ALL BEND RADII MAY BE 1/8" - 1/4" TO FACILITATE MANUFACTURING
1. MAKE FROM GPICK. DETAIL A' SHOWS TYP SPICE. LOCATION AND DIRECTION OF SPICES VERTICAL.

LAYOUT RELEASE - TO BE REDRAWN ON PRODUCTION FORM

MS 8-1100

H 26512		LW 280-8000	
H 26512		LW 280-8000	
H 26512		LW 280-8000	
H 26512		LW 280-8000	

SUPERSEDES LHM 830-15004 NC 5-12-66

NAS 9-1100

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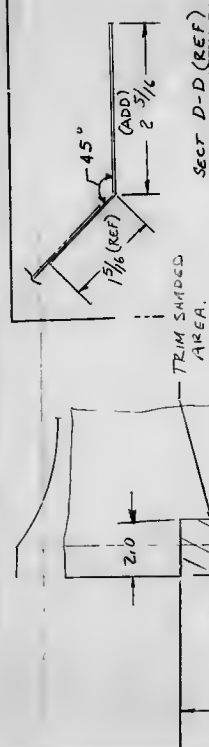
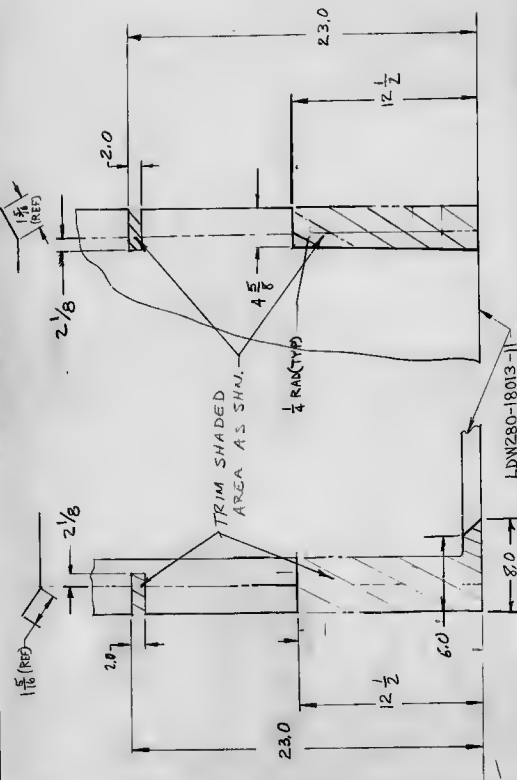
GRUMMAN AIRCRAFT ENGINEERING CORP.

CODE IDENT NO. 26312

 REV. NO. LDW280-18013
 CONTROL INFO NO. LM-5-9568
 SHEET NO. A2

ENGINEERING ORDER

FIG 333 REV 3-65

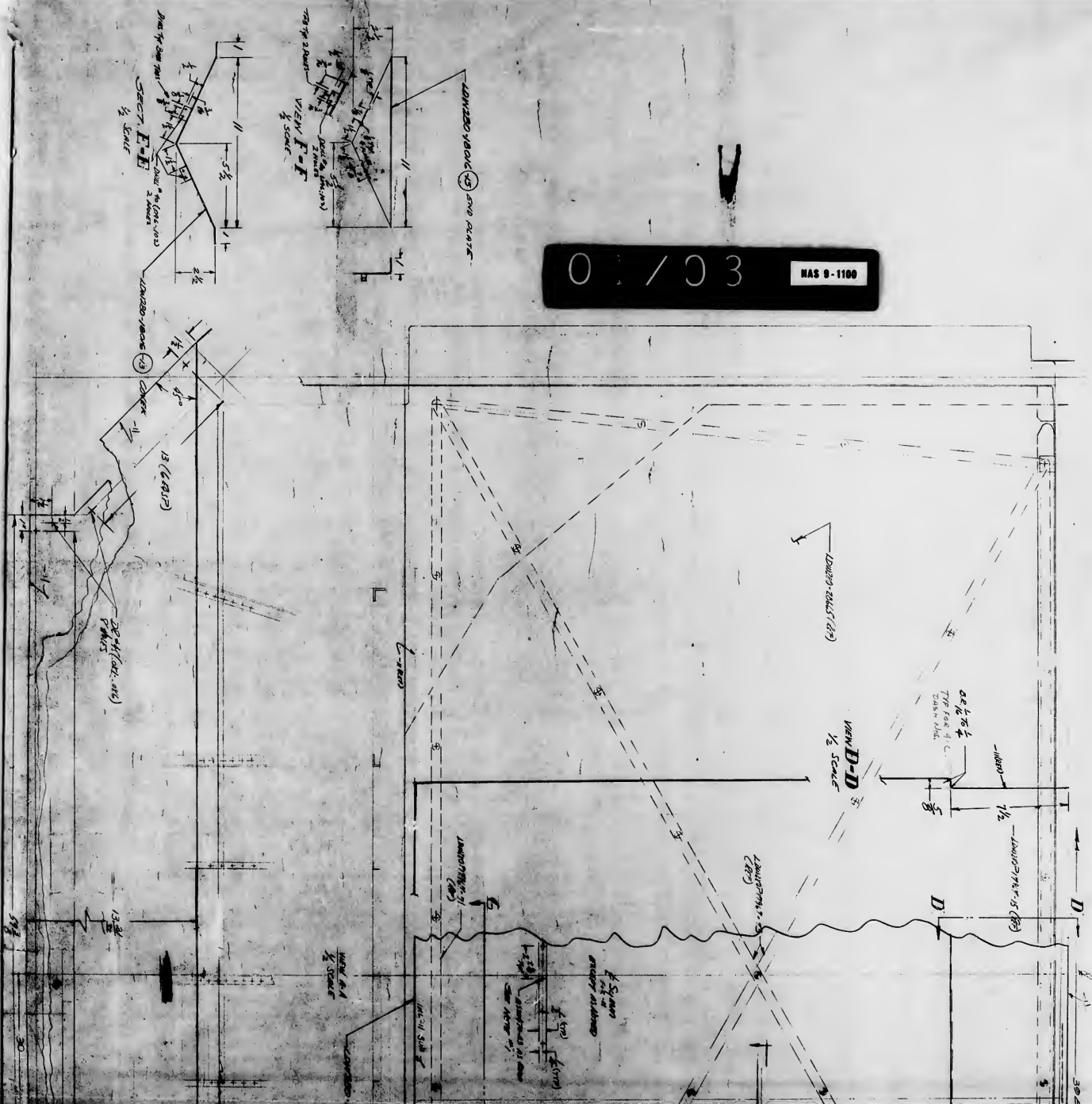

 ADD THE FOLLOWING TO NOTE #1 "LOCATION & DIRECTION OF SPLICES IS OPTIONAL".
 LDW280-18013-15

REVISIONS		DESCRIPTION OF CHG		DATE		BY		CHECKED		APPROVED		DATE		BY		CHECKED		APPROVED		DATE		BY	
1	ADD CUTOUTS IN ORDER TO CLEAR STRUCTURE	LDW280-18013-15	ADD CUTOUTS IN ORDER TO CLEAR STRUCTURE	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW
2	ADD CUTOUTS IN ORDER TO CLEAR STRUCTURE	LDW280-18013-15	ADD CUTOUTS IN ORDER TO CLEAR STRUCTURE	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW
3	ADD CUTOUTS IN ORDER TO CLEAR STRUCTURE	LDW280-18013-15	ADD CUTOUTS IN ORDER TO CLEAR STRUCTURE	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW
4	ADD CUTOUTS IN ORDER TO CLEAR STRUCTURE	LDW280-18013-15	ADD CUTOUTS IN ORDER TO CLEAR STRUCTURE	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW
5	ADD CUTOUTS IN ORDER TO CLEAR STRUCTURE	LDW280-18013-15	ADD CUTOUTS IN ORDER TO CLEAR STRUCTURE	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW	11/15/65	LDW

ISSUED BY: VINCENT CHRISTIAN / W-NAUT X1441 SECTION: VDI LIAISON PL 5 GROUP NO. 335 PL 5

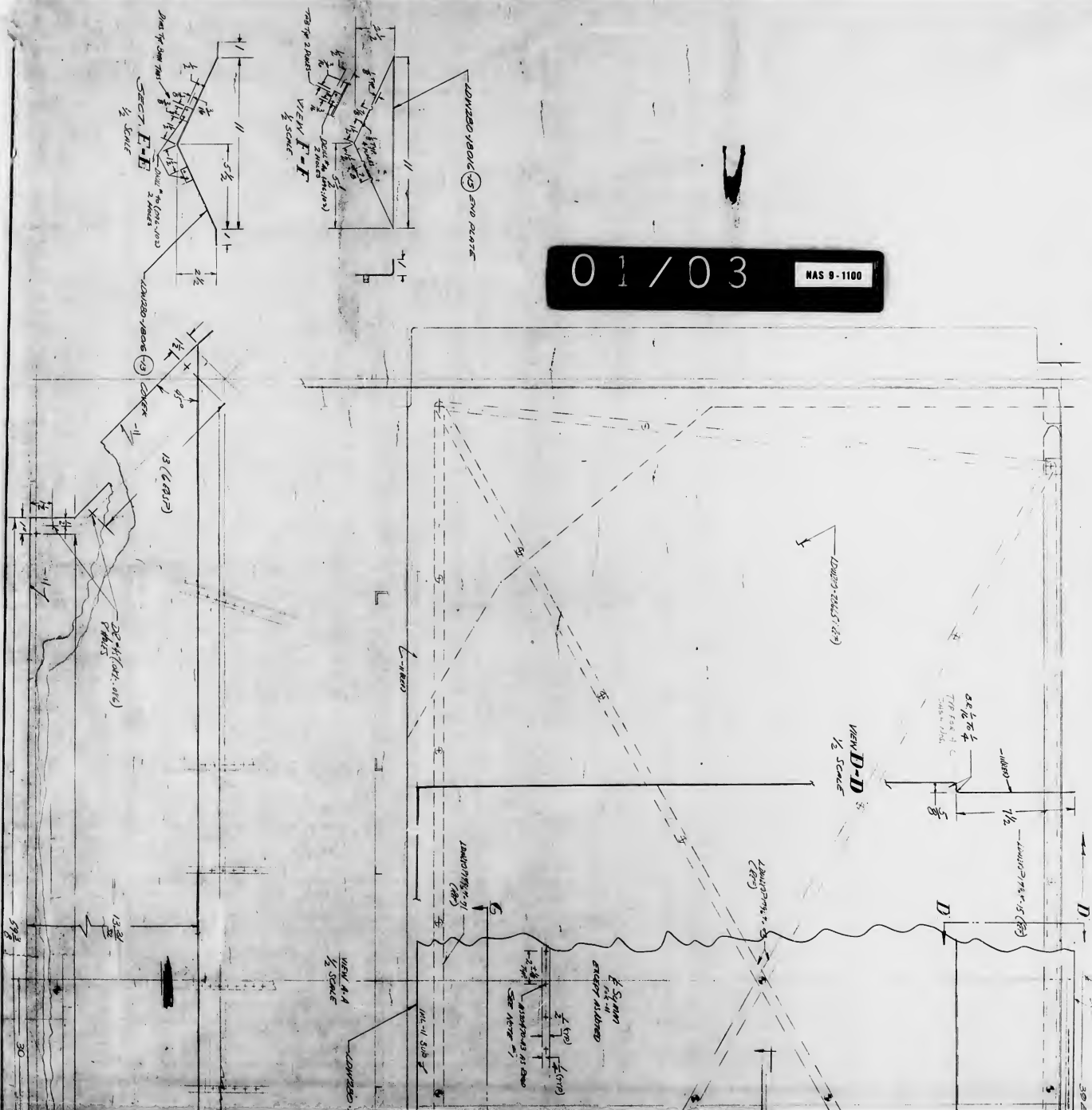
NAS 9-1100

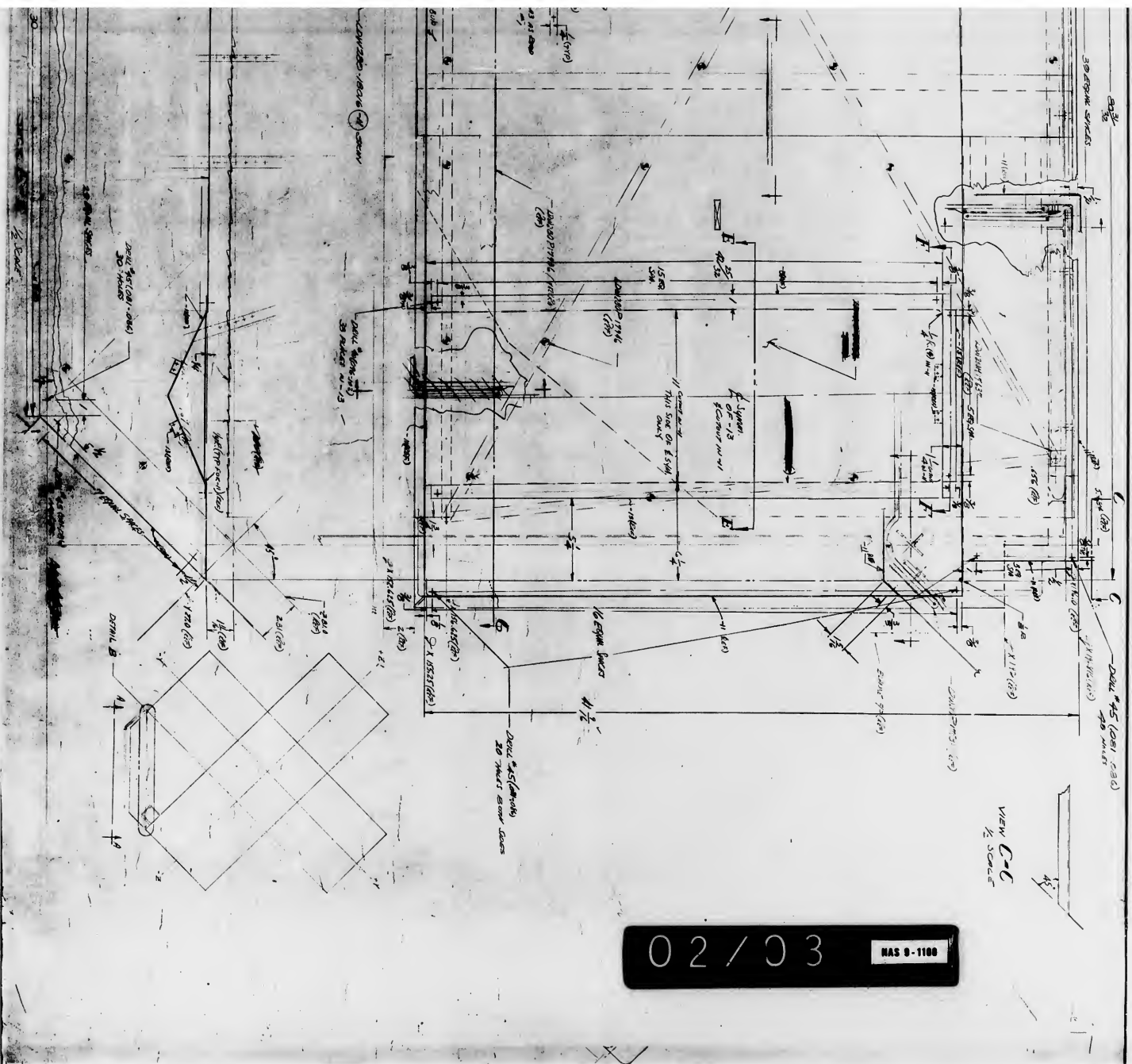
NAS 9-1100



01 / 03

NAS 9-1100





02/03

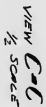
NAS 9-1100

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02 / 03

NAS 9-1100

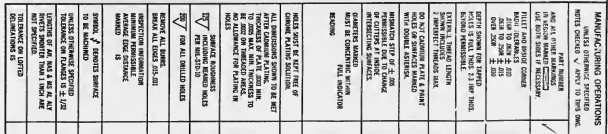


03 / 03

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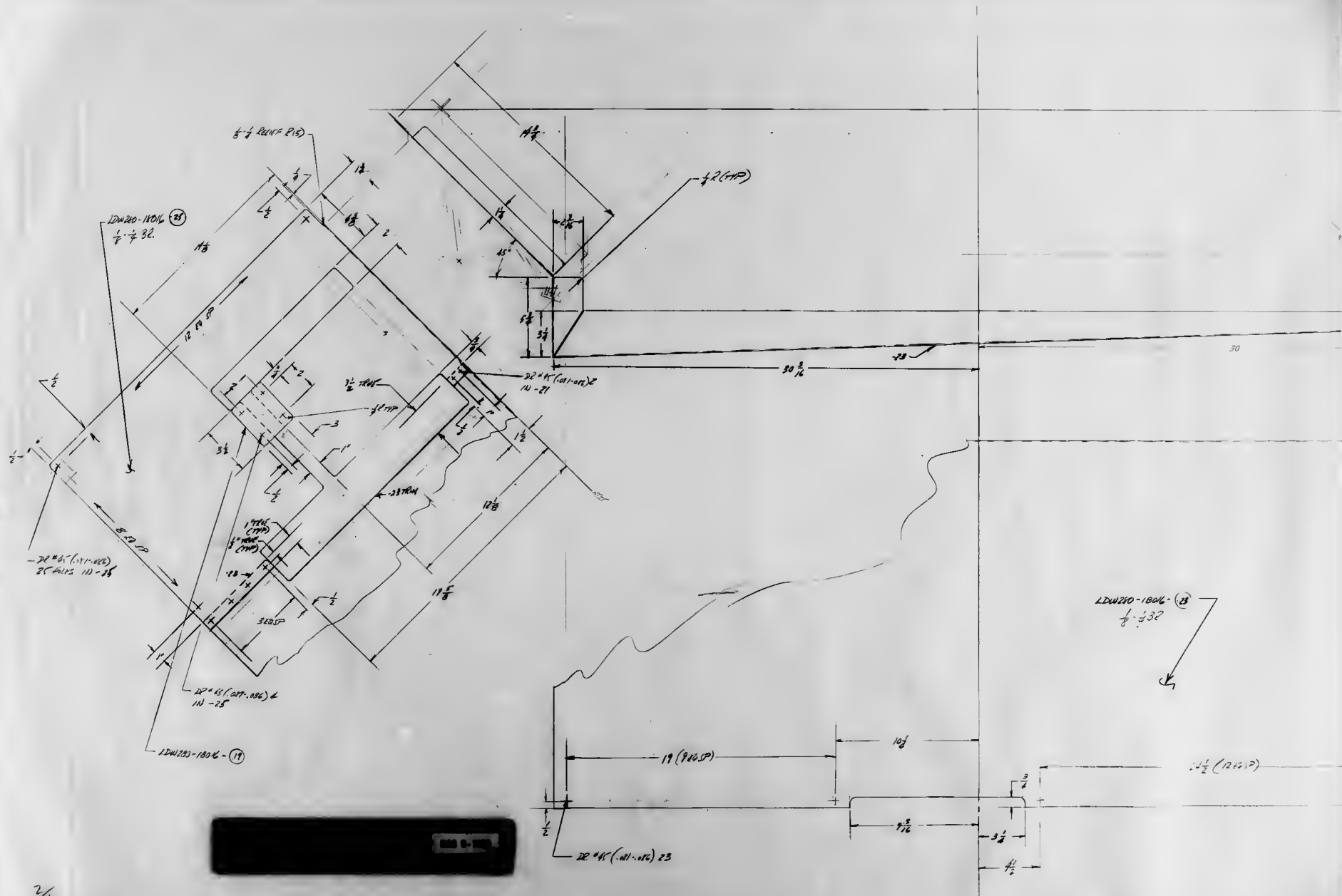


NAS 9-1100

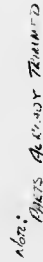
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LDW 283-1501A

GRIMMAN AIRCRAFT ENGINE CORP., BETHPAGE, L. I., NEW YORK		DATE	COPIES SHIPPED NO.	DATE	COPIES SHIPPED NO.
		J	26512	100 1950-18016	A
MAILED ON MAY 11/50		DATE	10/25/50	SHIPPED	2,000



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